

Date: Tuesday, 13/05/2008 9:30:16 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 39233					
Estimate Number	: 12731					
P.O. Number	:			Part Number	: D353535	
This Issue	: 13/05/2008		S.O. No.	: D3535 REV B		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 38760			Drawing Revision	: B	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08.5.13</u>			Due Date	: 30/05/2008	
Comment	: Est Rev:A New Issue 07-02-15 JLM			Qty:	20 Um: Each	
	Est Rev:B As per Rev B 07-08-31 JLM			Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		 Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s) <u>108 118 X 2 + 6</u> 6.8 304/316 .040 Sheet <u>107909 X 3 + 2</u> 4.5 (M304S20GA) Batch: <u>108 118 X 2 + 6</u> <u>107909 X 3 + 2</u> <u>13 8-5-27</u>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>13 8-5-27</u> Prog Rev: <u>B</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>13 8-5-27</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <u>13 8-5-27</u> Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE <u>13 8-5-27</u> Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 3-Identify as D3535-35.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:30:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39233

Part Number: D353535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/08/05/22/13

7.0 POWDER COATING

POWDER COATING



m/105642

13X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30

OVEN TEMPERATURE: 320

FINISH TIME: 8:00

M.F 08/05/28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14 08-05-28

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP417

20/08 08/08/28 13

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2008

Job Completion



MF 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39233
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

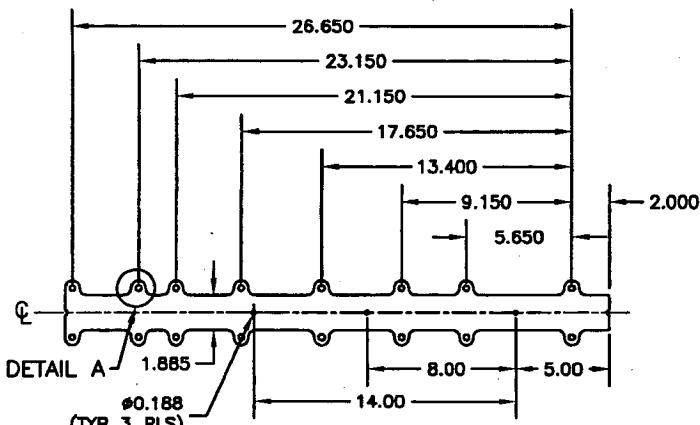
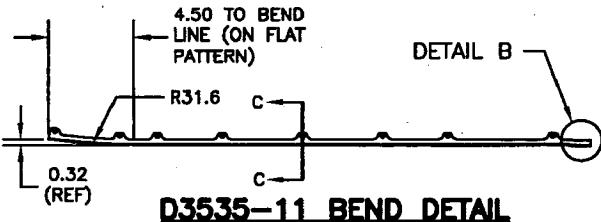
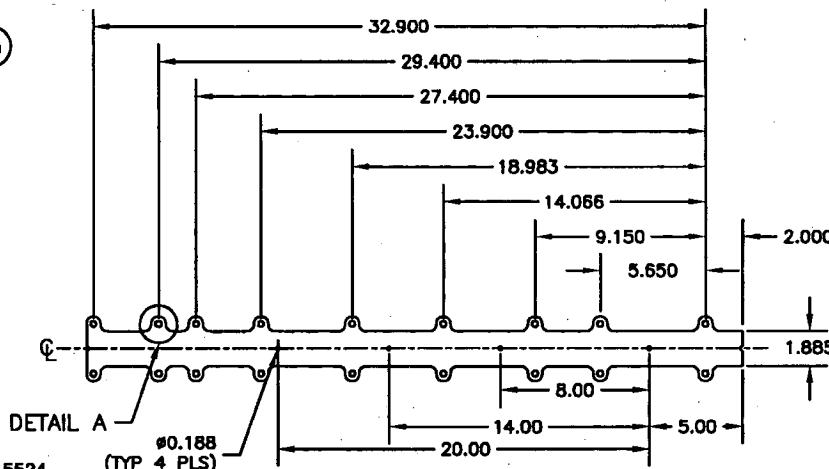
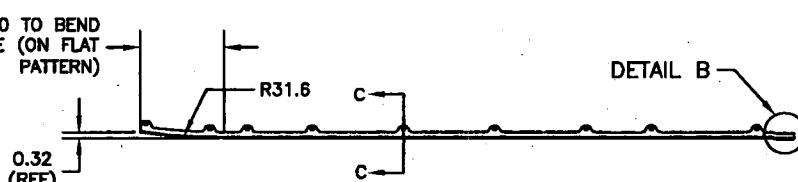
X First Article Prototype

Measured by: AB	Audited by: C	Prototype Approval: N/A
Date: 8-5-27	Date: 09/05/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM ✓	E

DART**RELEASED**

07 04 24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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NOTES

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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

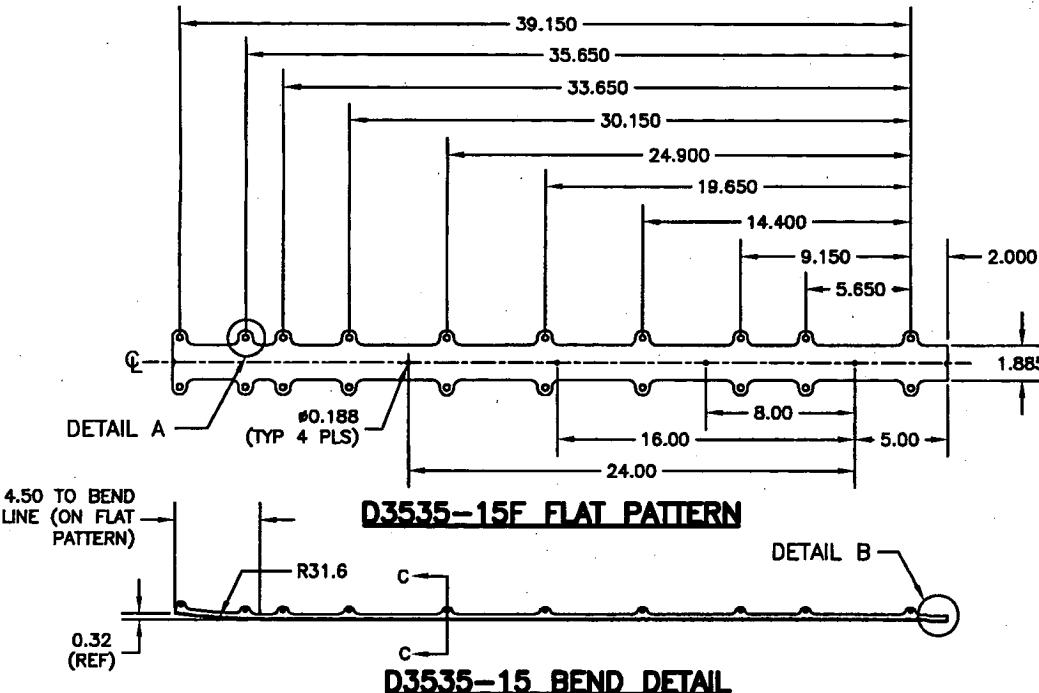
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07.04.17		WEARSHOE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SHEET 1 OF 7
		REV. B
		1:10
		SCALE

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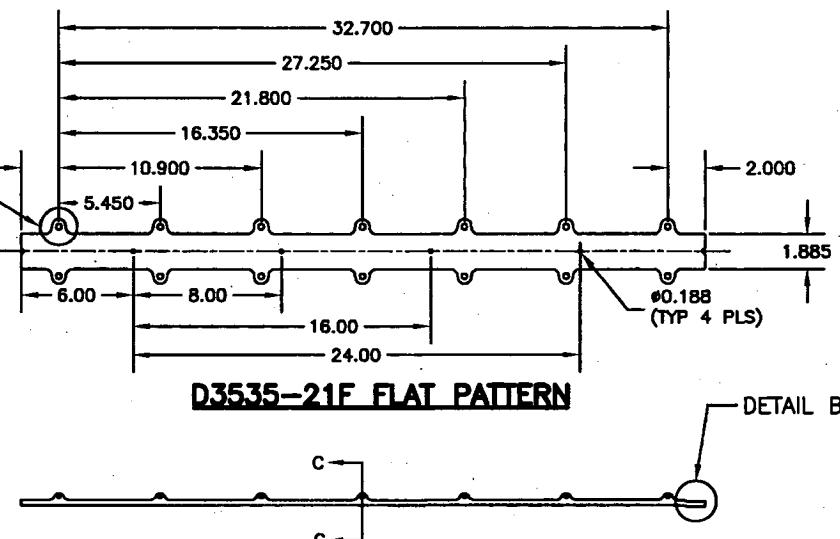
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- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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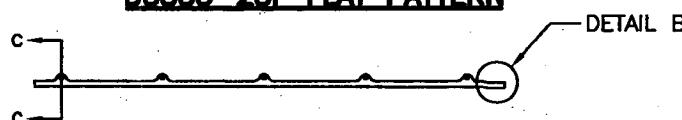
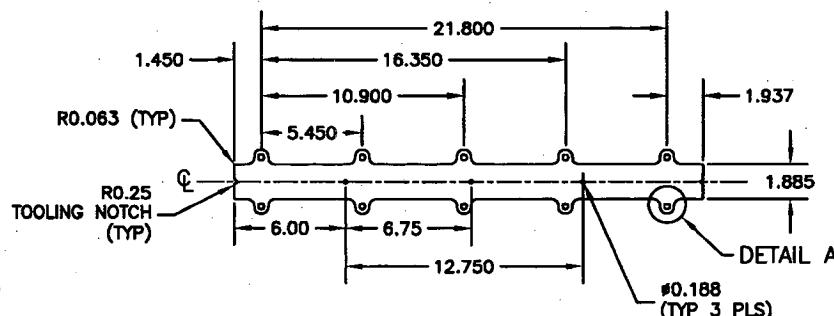
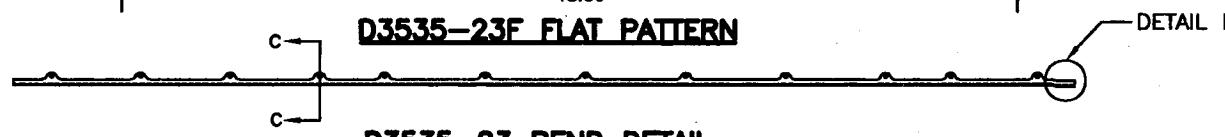
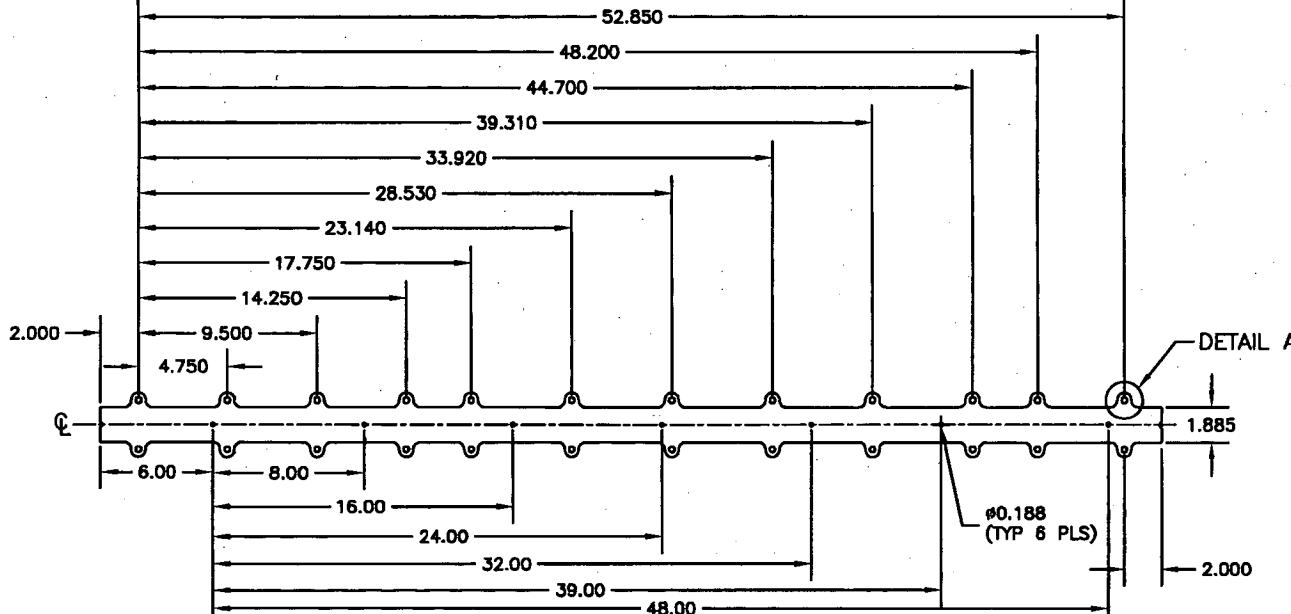


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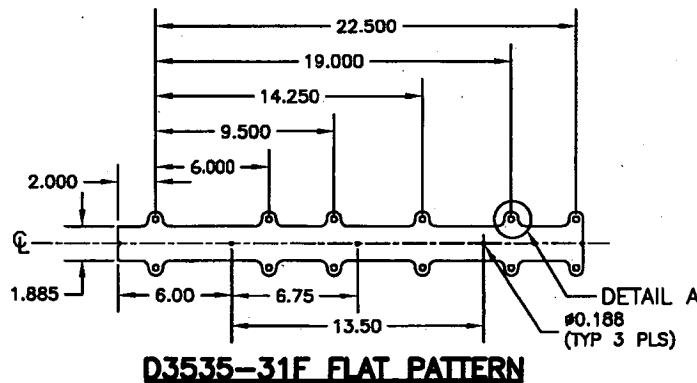
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- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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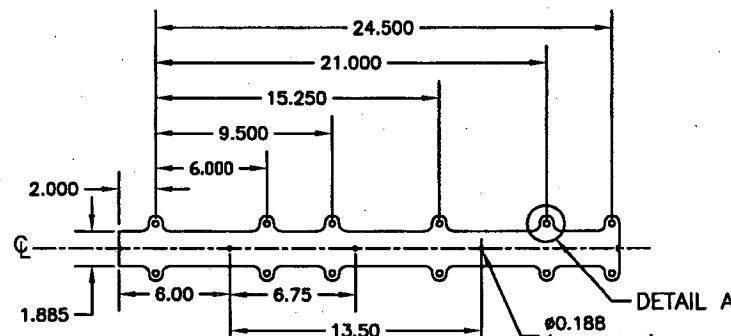
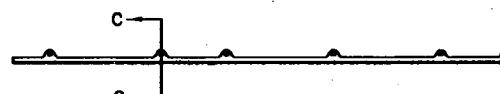
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07.04.24**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL**

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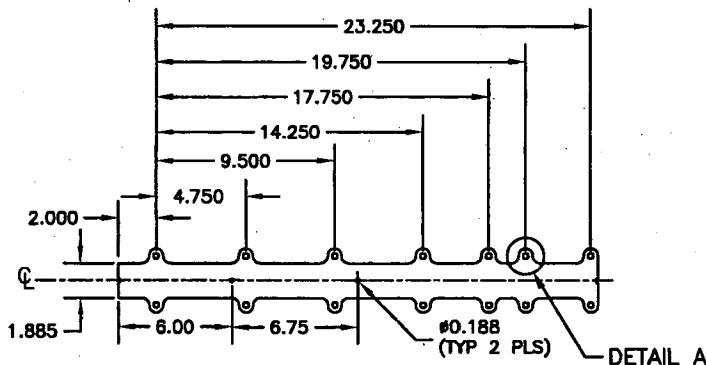
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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REV. B
SHEET 4 OF 7
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1:10

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07.04.14**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

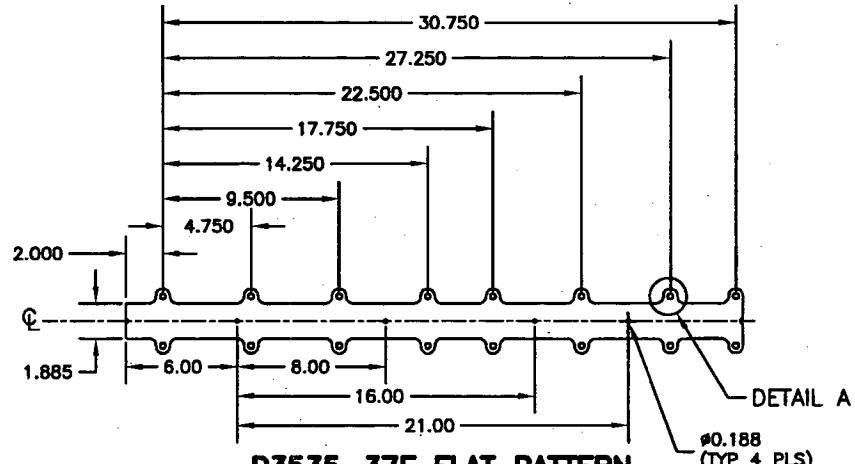
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

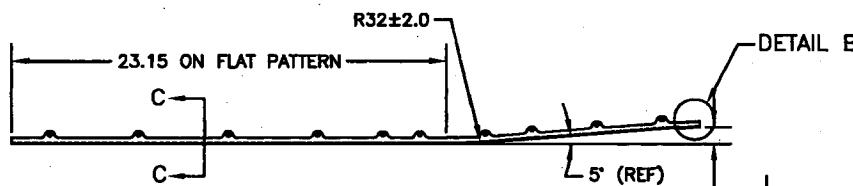
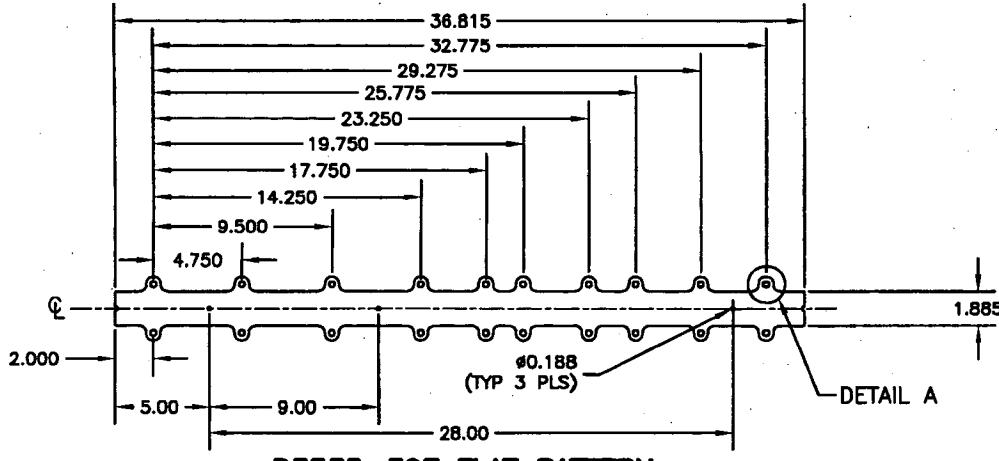
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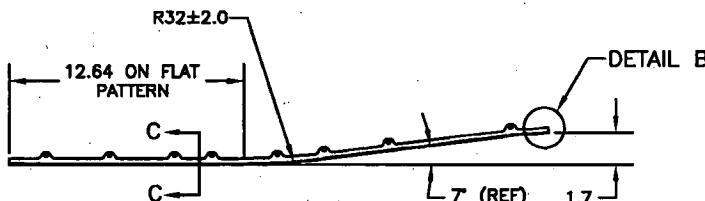
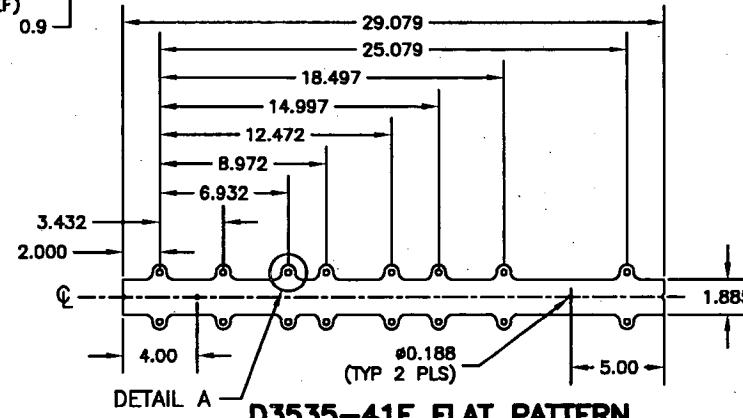
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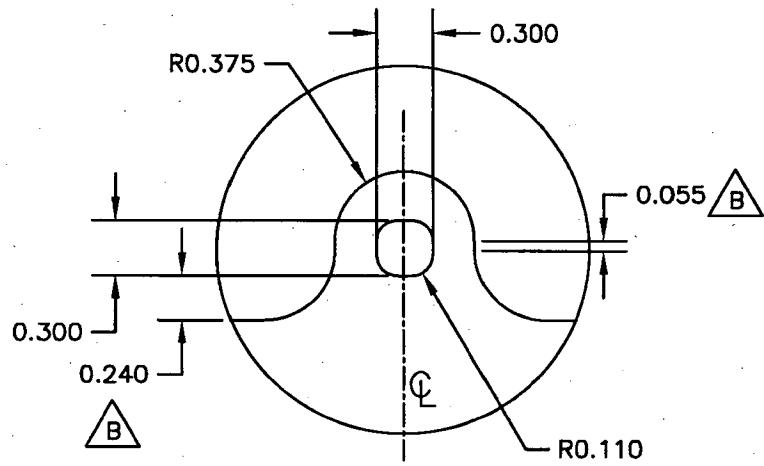
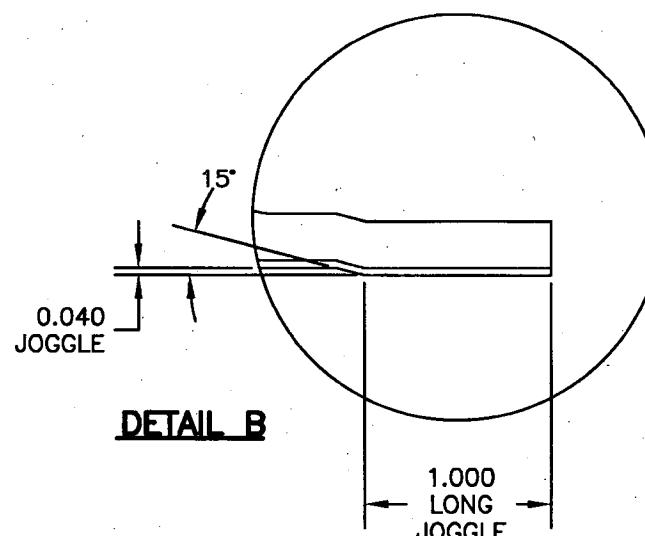
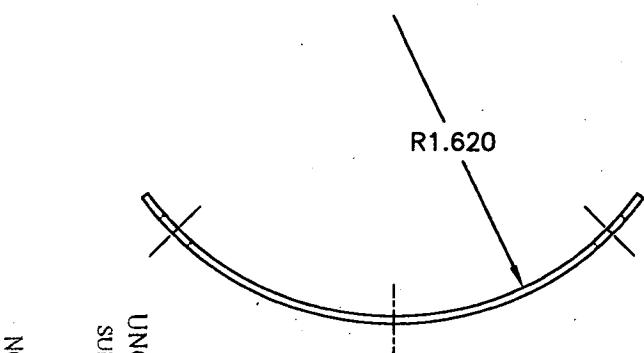
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		REV. B
		SHEET 6 OF 7
		SCALE
		1:10

NOTES

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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**DETAIL A****DETAIL B****SECTION C-C**

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